

Date: Monday, 6/12/2006 3:37:07 PM  
 User: KJn Johnson

## Process Sheet

*SLIP*

|                       |                                       |  |              |                         |               |          |
|-----------------------|---------------------------------------|--|--------------|-------------------------|---------------|----------|
| Customer              | : CU-DAR001 Dart Helicopters Services |  | Drawing Name | : FLOOR PROTCTOR FWD RH |               |          |
| Job Number            | : 27509                               |  |              |                         |               |          |
| Estimate Number       | : 11234                               |  |              |                         |               |          |
| P.O. Number           | : N/A                                 |  |              | Part Number             | : D32812      |          |
| This Issue            | : 6/12/2006 S.O. No. : N/A            |  |              | Drawing Number          | : D3281 REV B |          |
| Prsht Rev.            | : NC                                  |  |              | Project Number          | : N/A         |          |
| First Issue           | : N/A                                 |  |              | Drawing Revision        | : B           |          |
| Previous Run          | : 26354                               |  |              | Material                | : N/A         |          |
| Written By            | : <i>Seq A</i> COMMENT BELOW          |  |              | Due Date                | : 6/30/2006   |          |
| Checked & Approved By | : <i>Seq A</i> 06/06/13 K             |  |              | Qty:                    | 20            | Um: Each |
| Comment               | : Est Rev:A 04.07.01 New issue KJ/JLM |  |              |                         |               |          |

## Additional Product

Job Number:



| Seq. #: | Machine Or Operation: | Description :  |                           |
|---------|-----------------------|--|---------------------------|
| 1.0     | PG                    | PURCHASING   |                           |
|         |                       | Comment: PURCHASING<br>Issue P/O: <u>1493</u> <i>C:\del115\06 (20)</i>   |                           |
|         |                       | Description: Floor Protector Fwd, RH   |                           |
|         |                       | Possible Supplier: Delastek  |                           |
|         |                       | Certificate of Conformity is required  |                           |
| 2.0     | D32812P               | Floor Protector, Fwd RH  |                           |
|         |                       | Comment: Qty.: 1.0000 Each(s)/Unit Total : 20.0000 Each(s)<br>Floor Protector Fwd, RH  | <i>✓</i>                  |
| 3.0     | PACKAGING 1           | PACKAGING RESOURCE #1  |                           |
|         |                       | Comment: PACKAGING RESOURCE #1<br>Receive & Inspect For Transit Damage<br>Ensure certificate of conformity is attached                         | <i>P.D. 06/07/14 (18)</i> |
| 4.0     | QC6                   | DIMENSIONAL CHECK  | <br><i>QC6-07-18</i>      |
|         |                       | Comment: DIMENSIONAL CHECK<br>Inspect dimensions as per Dwg D3280 and certification attached. Visual inspection check for void spots and pins. | <i>18</i>                 |
| 5.0     | PACKAGING 1           | PACKAGING RESOURCE #1  | <br><i>QC6-07-18</i>      |
|         |                       | Comment: PACKAGING RESOURCE #1<br>Identify and Stock<br>Location: <u>  </u>  | <i>18</i>                 |

| W/O: |      | WORK ORDER CHANGES |  |    |      |     |                                 |                          |
|------|------|--------------------|--|----|------|-----|---------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   |  | By | Date | Qty | Approval<br>Mfg / Design<br>Mgr | Approval<br>QC Inspector |
|      |      |                    |  |    |      |     |                                 |                          |
|      |      |                    |  |    |      |     |                                 |                          |

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                  |                |                           |                        |                          |
|------|------|----------------------------------|-----------------------------|----------------------------------|----------------|---------------------------|------------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                  |                | Verification<br>Section C | Approval<br>Design Mgr | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Design Mgr       | Action Description<br>Design Mgr | Sign &<br>Date |                           |                        |                          |
|      |      |                                  |                             |                                  |                |                           |                        |                          |
|      |      |                                  |                             |                                  |                |                           |                        |                          |
|      |      |                                  |                             |                                  |                |                           |                        |                          |

Part No: \_\_\_\_\_

PAR #: \_\_\_\_\_

Fault Category: \_\_\_\_\_

NCR: Yes

No

Date: 06/07/25

NOTE: Date &amp; initial all entries

QA: N/C Closed: \_\_\_\_\_

Date: \_\_\_\_\_

Date: Monday, 6/12/2006 3:37:07 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOOR PROTCTOR FWD RH

Job Number: 27509

Part Number: D32812

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

6/6/07.19

Job Completion



u 6/6/07.18

| W/O: |      | WORK ORDER CHANGES |  |    |      |     |                                 |                          |
|------|------|--------------------|--|----|------|-----|---------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   |  | By | Date | Qty | Approval<br>Mfg / Design<br>Mgr | Approval<br>QC Inspector |
|      |      |                    |  |    |      |     |                                 |                          |
|      |      |                    |  |    |      |     |                                 |                          |

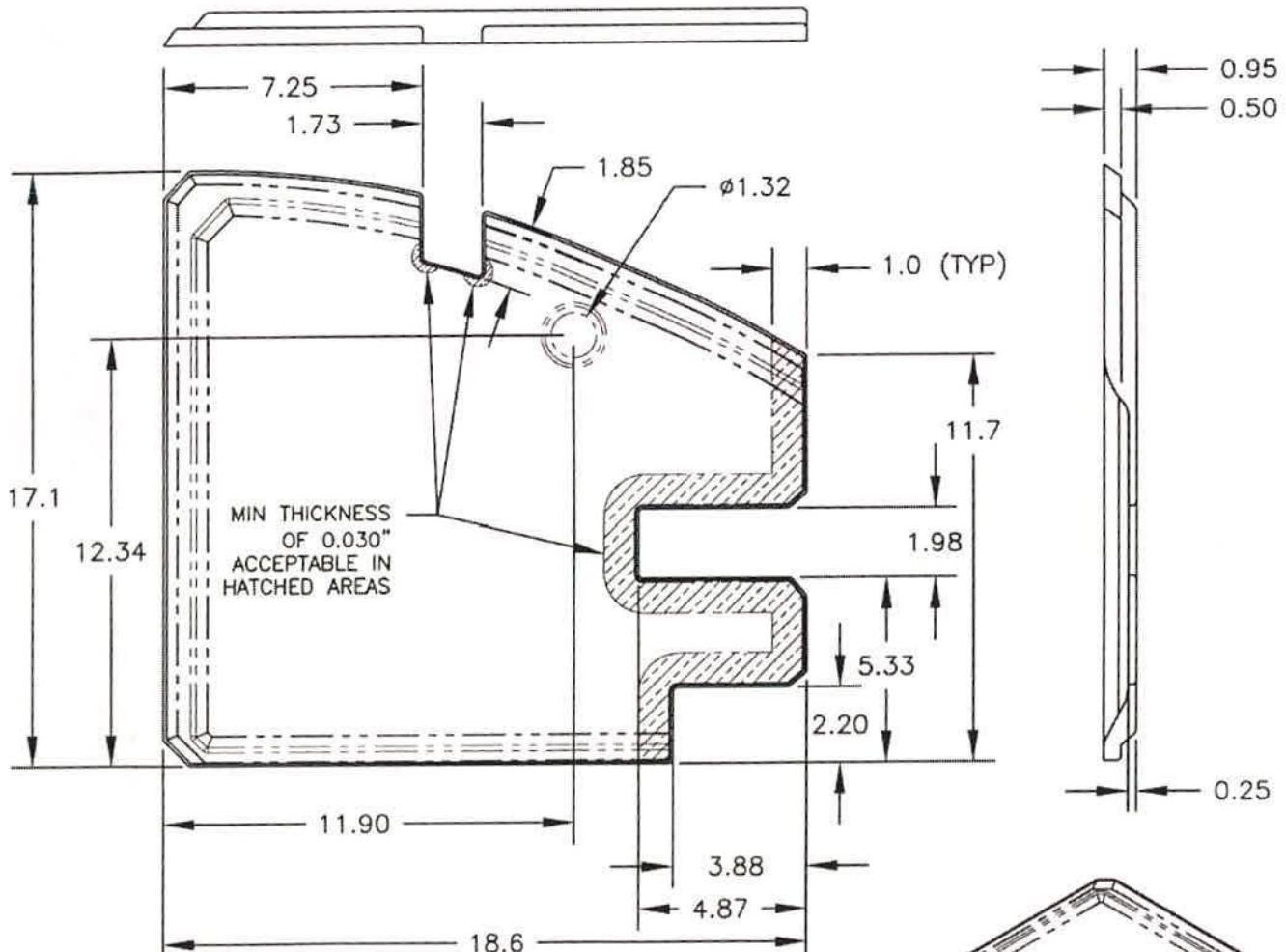
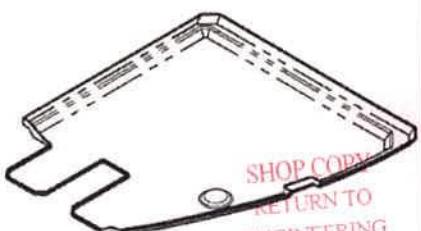
| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                  |                |                           |                        |                          |
|------|------|----------------------------------|-----------------------------|----------------------------------|----------------|---------------------------|------------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                  |                | Verification<br>Section C | Approval<br>Design Mgr | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Design Mgr       | Action Description<br>Design Mgr | Sign &<br>Date |                           |                        |                          |
|      |      |                                  |                             |                                  |                |                           |                        |                          |
|      |      |                                  |                             |                                  |                |                           |                        |                          |
|      |      |                                  |                             |                                  |                |                           |                        |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

NOTE: Date & initial all entries QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

**DART**

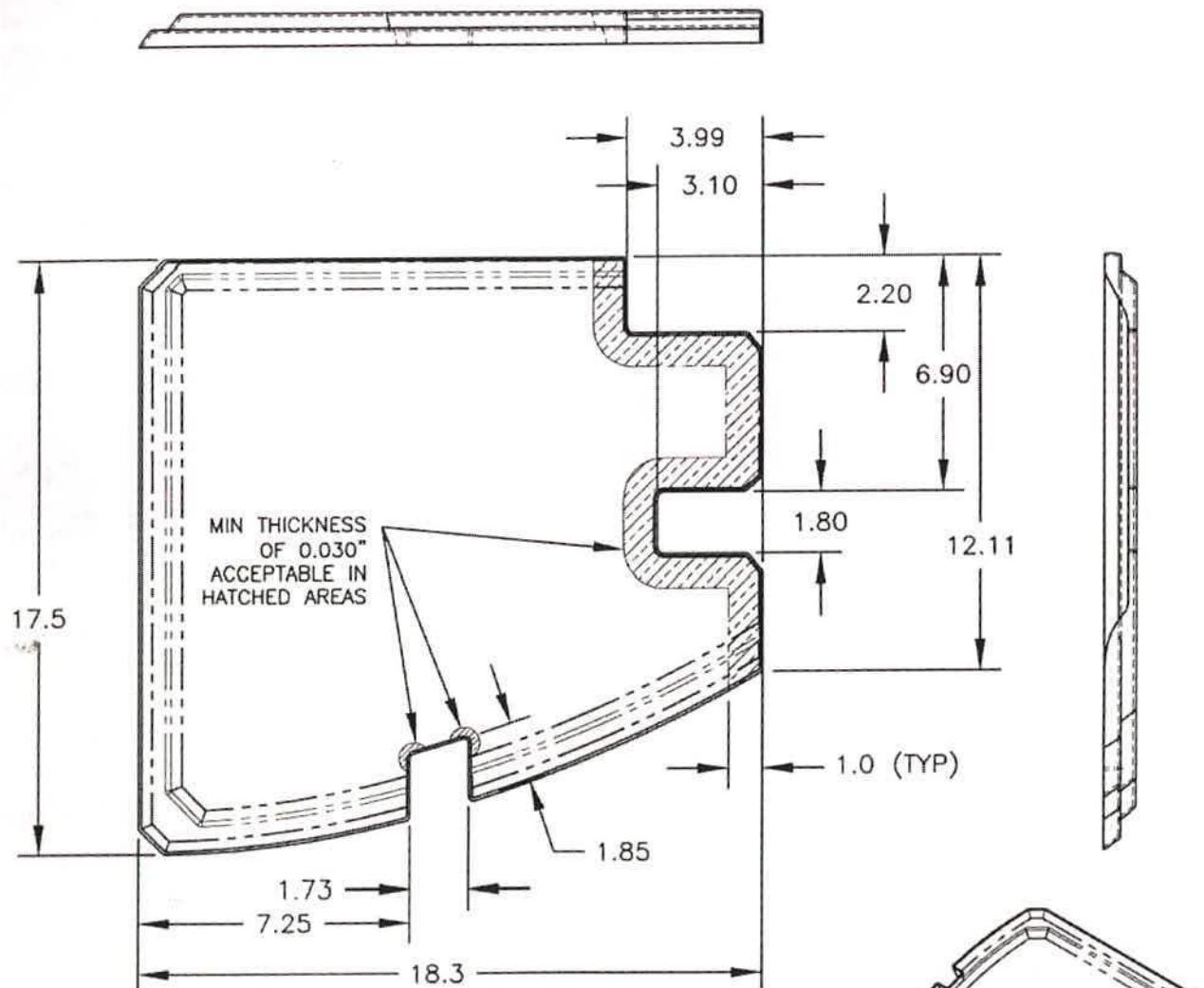
|          |          |   |
|----------|----------|---|
| DESIGN   | DRAWN BY | DART AEROSPACE LTD<br>HAWKESBURY, ONTARIO, CANADA |
| CHECKED  | APPROVED | DRAWING NO. D3281 REV. B<br>SHEET 1 OF 3          |
| DATE     |          | TITLE FLOOR PROTECTOR<br>SCALE 1:5                |
| 05.11.25 |          |   |
| A        | 04.05.03 | NEW ISSUE   |
| B        | 05.11.25 | NOW LEXAN; DIMS AS MANUFACTURED                   |

**RELEASED**  
05.12.01**D3281-1 FLOOR PROTECTOR, FWD LH**

- 1) THERMOFORM D3281-1 USING MOLD D3281-1T1, TRIM USING D3281-1T2
- 2) MATERIAL: LEXAN F6006 BLACK No.700, 0.125 THICK
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) MIN. THICKNESS AFTER FORMING IS 0.080" EXCEPT AS SHOWN

**DART**

|          |          |   |
|----------|----------|---|
| DESIGN   | DRAWN BY | DART AEROSPACE LTD<br>HAWKESBURY, ONTARIO, CANADA |
| CHECKED  | APPROVED | DRAWING NO. D3281                                 |
| DATE     |          | REV. B  |
| 05.11.25 |          | SHEET 2 OF 3                                      |
|          |          | TITLE   |
|          |          | SCALE   |
|          |          | 1:5   |

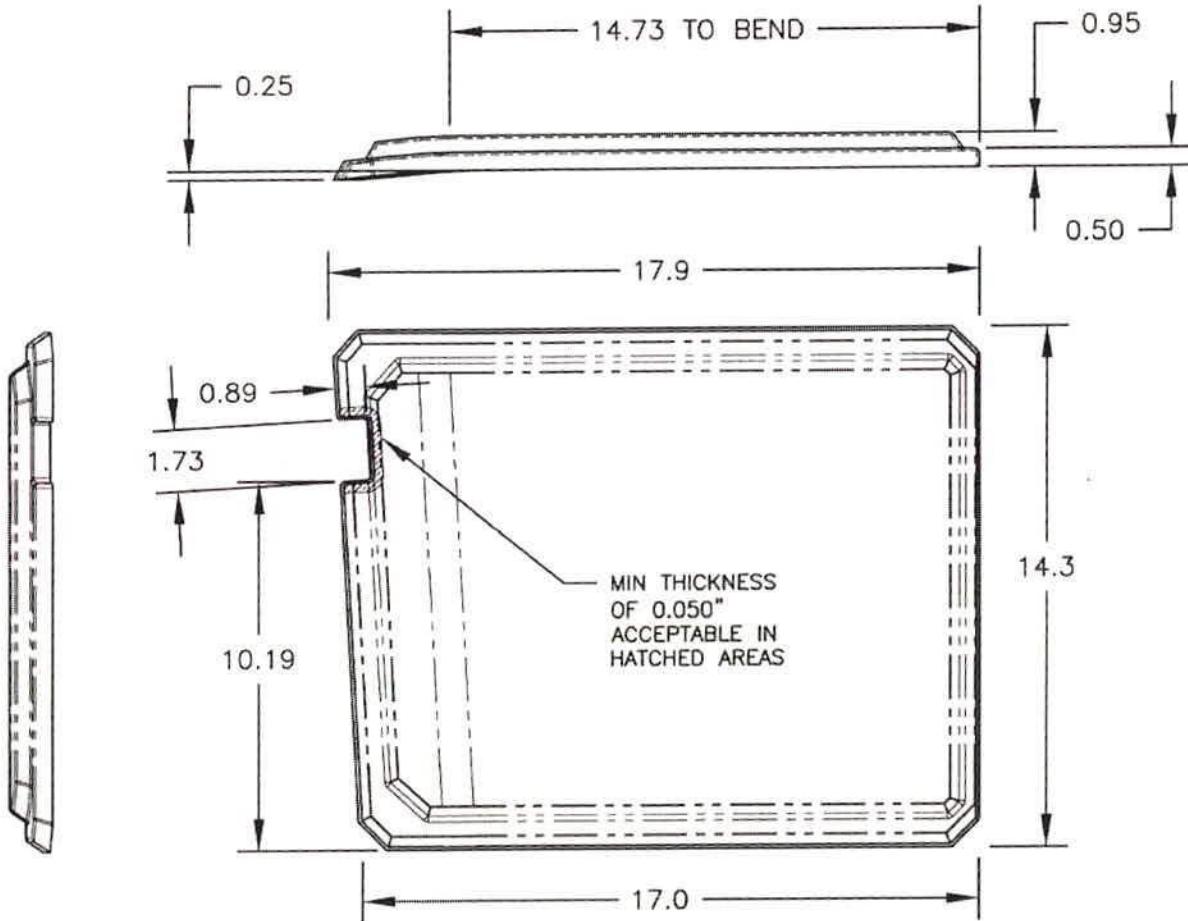
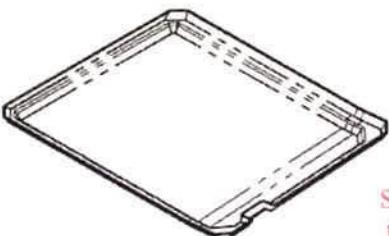
**RELEASED**  
05.12.01**D3281-2 FLOOR PROTECTOR, FWD RH**

- 1) THERMOFORM D3281-2 USING MOLD D3281-2T1, TRIM USING D3281-2T2
- 2) MATERIAL: LEXAN F6006 BLACK No.700, 0.125 THICK
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) MIN. THICKNESS AFTER FORMING IS 0.080" EXCEPT AS SHOWN

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WORK ORDER  
NO. 27509

**DART**

|         |          |  |
|---------|----------|--|
| DESIGN  | DRAWN BY | DART AEROSPACE LTD<br>HAWKESBURY, ONTARIO, CANADA            |
| CHECKED | APPROVED | DRAWING NO. D3281  |
| DATE    | 05.11.25 | REV. B<br>SHEET 3 OF 3<br>TITLE FLOOR PROTECTOR<br>SCALE 1:5 |

**RELEASED**  
05.12.01. *[Signature]***D3281-3 FLOOR PROTECTOR, AFT LH (SHOWN)****D3281-4 FLOOR PROTECTOR, AFT RH (OPPOSITE)**

- 1) THERMOFORM D3281-3 USING MOLD D3281-3T1, TRIM USING D3281-3T2
- 2) THERMOFORM D3281-4 USING MOLD D3281-4T1, TRIM USING D3281-4T2
- 3) MATERIAL: LEXAN F6006 BLACK No.700, 0.125 THICK
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) MIN. THICKNESS AFTER FORMING IS 0.080" EXCEPT AS SHOWN

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WITHOUT NOTICE

WORK ORDER

NO. 27509

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DELASTEK COMPOSITES INC.  
2699, 5ième Avenue  
Local 14, PORTE -A-  
Grand-Mère, Québec G9T 5K7  
Can \*\*Fax (819) 533-3494 \*\*

Telephone: (819) 533-5788

Warehouse: MAIN

Bill to:

Dart Aerospace Ltd.  
1270, Aberdeen Street  
Hawkesbury, Ontario K6A 1K7  
Canada

Telephone: 613-632-3336

Contact: Linda Lacelle

# PACKING SLIP

## CERTIFICATE OF COMPLIANCE

|            |       |
|------------|-------|
| Invoice #  | 10766 |
| Customer # | DART  |

Ship to:

Dart Aerospace Ltd.  
1270, Aberdeen Street  
Hawkesbury, Ontario K6A 1K7  
Canada

| Ship via     |            | F.O.B.        |             | Terms  |  | Salesperson              |  |  |  |
|--------------|------------|---------------|-------------|--|--|--------------------------|--|--|--|
| PURO COLLECT |            | Origin        |             | Net30 days   |  | Claude Lessard, ext. 233 |  |  |  |
| Ship date    | Order Date | Our PO #      | Order by    | Your PO #  |  | GST/PST #                |  |  |  |
| 14/07/06     | 15/06/06   | 4716          | C. Lavoie   | PO00001493   |  |                          |  |  |  |
| Order Qty    | B.O. Qty   | Current Ship. | Item #      | Item Description   |  |                          |  |  |  |
| 20           | 2          | 18            | DKC134-0045 | Floor Protect Part 2 N° D3281-2 (F6006 )<br>Selon dessin D3181 Rev.: B<br>D3281 NS<br>JOB: 36893 QTÉ: 18 |  |                          |  |  |  |

It is hereby certified that all materials, process and finished items were controlled and tested in accordance with the requirements of the purchase order and applicable specifications. All such records are on file at our plant and available for review upon request.

Accepted by:



Quality department AQ-357

Cust.

Adm.

Quality

Ship.

Date: Jeudi, 2006-06-22 10:51:18  
Utilisateur: Marc Dubé

## Feuille de Procédé

Client : DART Dart Aerospace Ltd.  
Numéro Job : 36893  
Numéro Soumission : 2384  
Numéro B.A. :  
Cette fois : 2006-06-22 No. B.V. :  
Prsht Rev. : NC  
Prem. fois : -- Type :  
Job précédente : 34174  
Écrit par :  
Vérifié & Approuvé par :  
Commentaires : N° de pièce: D3281-2

Nom Dessin : FLOOR PROTECTOR  
Numéro Article : DKC134-0045  
Numéro Dessin : D3281  
Projet Numéro : DKC134  
Révision dessin : B  
Matériel : F6006  
Date Dûe : 2006-06-29  
Qté: 20 Udm: UNITE

✓

(DELASTEK  
COMPOSITES  
15)

Process Sheet Rév.: 00 Création du premier

## Produit additionnel

Numéro Job:



| # Séq.: | Machine ou Opération: | Description:   |
|---------|-----------------------|--|
| 1.0     | APL0016               | Lexan F6006 Noir N° 700 48" x 96" x .125" Thk.<br>Commentair Qty.: 0.167 UNI<br>Lexan F6006 Noir |
|         |                       | N° de Lot: _____<br># Bon achat: 5327 SÉCHAGE / ANEALING   |
| 2.0     | SÉCHAGE / ANEAL       | Lexan F6006 Noir N° 700 48" x 96" x .125" Thk.   |

Commentair Setup: 0.00Hrs/ Run: 2.0000Min Total Run : 0.6667Hrs

## SÉCHAGE DU MATÉRIEL

Sécher le matériel dans le four à 250° F pendant 6 heures.

Inscrire sur la charte de température le numéro de Job du matériel au séchage.

# de cuisson: 5140

|     |               |                              |
|-----|---------------|------------------------------|
| 3.0 | PRÉPARATION 3 | PRÉPARATION DU MATÉRIEL DART |
|     |               |                              |

Commentair Setup: 0.00Hrs/ Run: 3.0000Hrs Total Run : 60.0000Hrs

## TAILLAGE DU MATÉRIEL

Faire le taillage du matériel selon les dimensions suivantes:

24" x 26" x .125" Thk.

Quantité: 10 Date: 5-7-06 Sceau:

Quantité: 10 Date: 13.07.06 Sceau: E. B.

## Feuille de Procédé

Client: DART Dart Aerospace Ltd.  
Numéro Job: 36893

Nom Dessin: FLOOR PROTECTOR  
Numéro Article: DKC134-0045

Numéro Job:



| # Séq.: | Machine ou Opération: | Description :                |
|---------|-----------------------|------------------------------|
| 4.0     | THERMOFORMAGE2        | THERMOFORMAGE DES PIÈCE DART |



Commentair Setup: 0.50Hrs/ Run: 10.0000Min Total Run : 3.3333Hrs  
THERMOFORMAGE DES PIECES

F.O: 4 juillet 06



Faire le thermoformage du "Floor Protector" N° D3281-2 à l'aide du moule N° D3281-2T1 sur le thermoformeur 4' x 8'.

Autocontrôle du lot de pièce thermoformées.

Quantité: 20 Date: 5-7-06 Sceau:

F.O: 12-07-06

Quantité: 10 Date: 13.07.06 Sceau: E.B.

5.0 TRIMAGE 3 TRIMAGE COMPOSITES DART



Commentair Setup: 0.00Hrs/ Run: 10.0000Min Total Run : 3.3333Hrs  
TRIMAGE PLASTIQUE DART



① Faire le trimage du "Floor Protector" N° D3281-2 à l'aide du gabarit de trimage N° D3281-2T2.  
② Cise l'abavurage des pièces.

10x 13.07.06 E.B.

F.O: 6 juillet 06

Autocontrôle de la pièce trimées.

① Quantité: 20 Date: 7-7-06 Sceau:



② Quantité: 20 Date: 11-07-06 Sceau:

8 (13-07-06)



6.0 INSPECTION 3 INSPECTION PIÈCE DART



Commentair Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 1.6667Hrs  
INSPECTION PIÈCE DART

Rejets à l'inspech

Faire l'inspection finale des pièces selon le dessin.

Quantité: 18 Date: 13-07-06 Sceau:

Voir emballage pour autre inpech

7.0 IDENTIFICATION4 IDENTIFICATION PIÈCES DART



Commentair Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 1.6667Hrs  
IDENTIFICATION PIÈCES DART

Faire l'identification des pièces à l'aide des informations suivantes:

Date: Jeudi, 2006-06-22 10:51:18  
Utilisateur: Marc Dubé

## Feuille de Procédé

Client: DART Dart Aerospace Ltd.

Nom Dessin: FLOOR PROTECTOR

Numéro Job: 36893

Numéro Article: DKC134-0045

Numéro Job:



# Séq.: Machine ou Opération:

Description :

N° de pièce: D3281-2

10x 13.07.06 E.B.

N° de Job: \_\_\_\_\_

Date de fabrication: \_\_\_\_\_

Sceau d'inspection:

Quantité: 15

Date: 13-07-06 Sceau:

5 rejets

Quantité: 8

Date: 13-07-06 Sceau:

8.0 EMBALLAGE

EMBALLAGE ET ENTREPOSAGE



Commentair Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 1.6667Hrs

EMBALLAGE ET ENTREPOSAGE

Emballer les pièces individuellement dans un sac en plastique et ensuite mettre dans une boîte en carton identifiée comme suit:

N° de pièce: D3281-2

Date de fabrication: \_\_\_\_\_

N° de job: \_\_\_\_\_

Quantité: 10

Date: 13-07-06 Sceau:

10 def e.b

Quantité: 18

Date: 13-07-06 Sceau:

5 rejets #RNC : 01133